

Work Order ID 61502

Friday, August 27, 2010 3:28:06 PM



Page 1

Item ID: D3535-33

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 8/30/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: MEDate: 16-8-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 .040

B 10-9-8



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-9-8

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/09/09



Pho →

W/O: 61502		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/9/09	#20	Took Qty +1 For QC inspection template	S	10/09/09	x1		S 10/09/09

Part No: D3535-33 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. □2-
Identify as D3535-33.

SA 12/09/09

(13)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.10.09/09

(13)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: 10:20 □ OVEN TEMPERATURE:
320 FINISH TIME: 10:50

BH 10-9-10

M 112588

(13)

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

M 10/09/13

Memo

0.00

13

170



Packaging

Packaging

Identify as per dwg & Stock Location:

FR-19

0.00

BR 10-9-13

Memo

0.00

13

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/14

M 10-9-13

(13)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, August 27, 2010 3:28:06 PM

Page 1

Work Order ID: 61502



Parent Item: D3535-33



Parent Item Name: Wearshoe



Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	118.2987	0.6445	8.141053	8.14 9.		
304/316 .040 Sheet											1810-9-8		

Location

Loc Qty

Loc Code

MAT	16.1522	
114574	16.1522	
MAT20	102.1465	
112885	2.7475	
113062	0.699	
115440	98.7	

115440

(18)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61902
Description: Wearshoe		Part Number: D3535-33
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.189	X		V	
0.300	+/-0.010	.301	>		V	
0.300	+/-0.010	.302	X		V	
1.885	+/-0.010	1.891	X		V	
2.000	+/-0.010	2.000	X		V	
6.000	+/-0.010	6.000	T		T	
9.500	+/-0.010	9.500	X		T	
15.250	+/-0.010	15.250	X		T	
21.000	+/-0.010	21.000	X		T	
24.500	+/-0.010	24.500	2		T	
6.00	+/-0.030	6.00	X		T	
6.75	+/-0.030	6.75	X		T	
13.50	+/-0.030	13.50	4		T	
0.040	+/-0.010	.034	X		V	

Measured by: JB	Audited by: S	Prototype Approval: N/A
Date: 10-9-8	Date: 10/01/09	Date: N/A

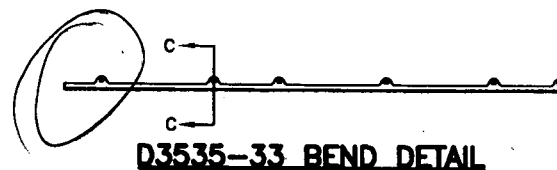
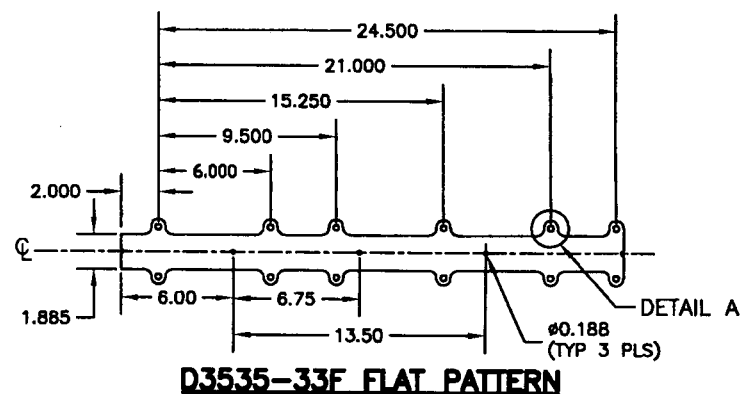
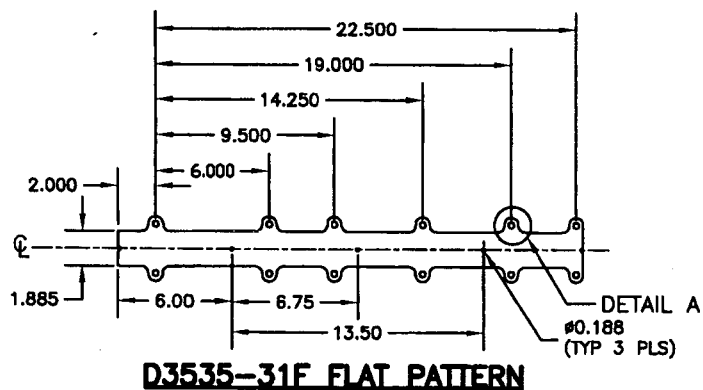
Rev	Date	Change	Revised by	Approved
A	09.10.16	New Issue	KJ	

DART

RELEASED

07.04.24

#61502



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI.005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

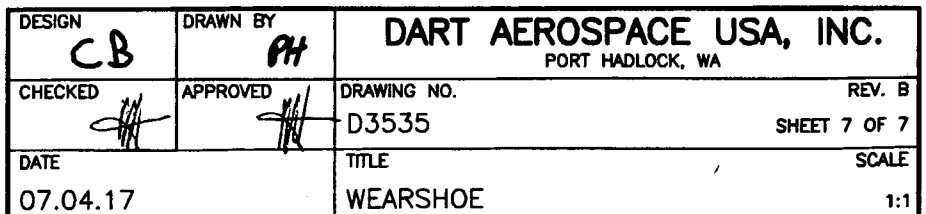
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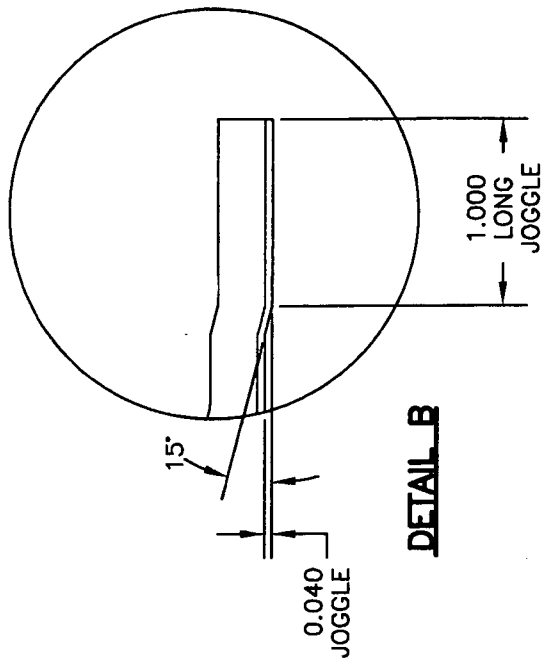
NOTE: Date & initial all entries



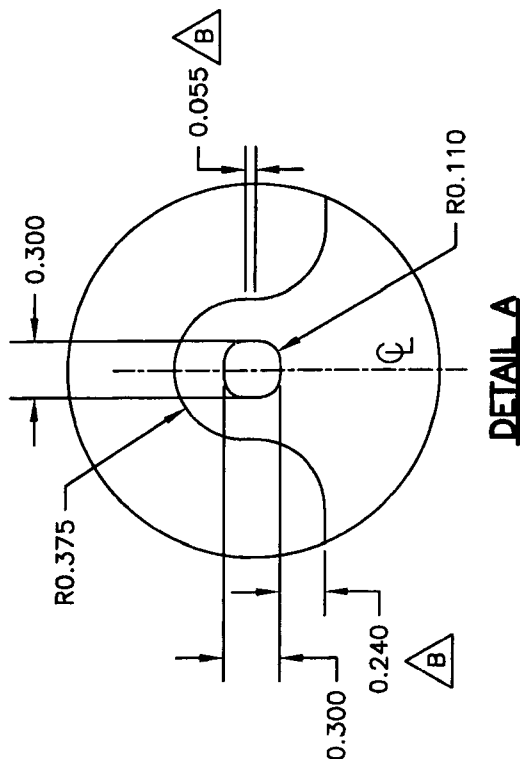
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07.04.24

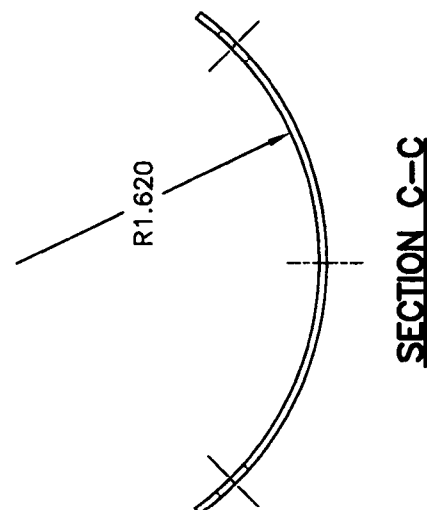
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DETAIL B



DETAIL A



SECTION C-C

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